

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004975**Date Inspected:** 04-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG and tower components				

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

LIFT 1 SKIN C.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed welds made between assembly component members on the inspection part number: NSD1-SA17A/G, NSD1-SA179D/E, NSD1-SA179B1/E, NSD1-SA179B2/E, NSD1-SA179B/E and NSD1-SA179C/E of the LIFT 1 SKIN C section (please note that multiple welds were verified on these inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001548 item number 3 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel Zhang Qin Jian and Task Leader Albert Carreon of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Tower diaphragm 62M.

2. The QA Inspector performed VT and MT verifications on a weld repaired area made on a complete joint penetration weld made between assembly component members on the inspection part number: ESD1-SA411 weld number 2 of the diaphragm 62M tower section. Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001548 item number 1 for additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assembly. The QA Inspector performed the verifications on this weld after ZPMC Quality Control Inspection personnel had completed the inspections and reported the weld to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspection personnel Zhang Huilong and Task Leader Albert Carreon of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

East tower skin A

3. The QA Inspector assisted by QA Inspector Paul Dawson performed a random VT and MT verifications on the completed welds made between assembly component members on the inspection part number: ESD1-SA300D/F weld number 14, 30 and 32A, ESD1-300E/F weld number 14, 30 and 32A of the east tower skin A section. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies. The QA Inspectors performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspectors did not observe any welding related discontinuities and did not observe any relevant indications during verifications. Please note that the ZPMC personnel were performing grinding on the assembly components to prepare assembly for the final visual inspection. The QA Inspectors did not perform the final visual inspection on this assembly on this shift. The QA Inspector notified Task Leader Albert Carreon of the observations mentioned above during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
